considered a part of the base plate when determining the thickness. If cladding material does not have tensile strength at least equal to the base plate, the base plate alone shall meet the thickness requirements.

[29 FR 18995, Dec. 29, 1964, as amended by Order 71, 31 FR 9083, July 1, 1966. Redesignated at 32 FR 5606, Apr. 5, 1967; 66 FR 45186, 45390, Aug. 28, 2001]

§ 179.300–7 Materials.

(a) Steel plate material used to fabricate tanks must conform with the following specifications with the indicated minimum tensile strength and elongation in the welded condition. However, the maximum allowable carbon content for carbon steel must not exceed 0.31 percent, although the individual ASTM specification may allow for a greater amount of carbon. The plates may be clad with other approved materials:

Specifications	Tensile strength (psi) welded condition [1] (minimum)	Elongation in 2 inches (percent) welded condition [1] (longitudinal) (minimum)
ASTM A 240 type 304	75,000	25
ASTM A 240 type 304L	70,000	25
ASTM A 240 type 316	75,000	25
ASTM A 240 type 316L	70,000	25
ASTM A 240 type 321	75,000	25
ASTM A285 Gr. A	45,000	29
ASTM A285 Gr. B	50,000	20
ASTM A285 Gr. C	55,000	20
ASTM A515 Gr. 65	65,000	20
ASTM A515 Gr. 70	70,000	20
ASTM A516 Gr. 70	70,000	20

[1] Maximum stresses to be used in calculations.

(b) [Reserved]

(c) All plates must have their heat number and the name or brand of the manufacturer legibly stamped on them at the rolling mill.

[Amdt. 179–10, 36 FR 21355, Nov. 6, 1971, as amended by Amdt. 179–42, 54 FR 38798, Sept. 20, 1989; Amdt. 179–43, 55 FR 27642, July 5, 1990; Amdt. 179–52, 61 FR 28682, June 5, 1996; Amdt. 179–52, 61 FR 50255, Sept. 25, 1996; Amdt. 179–53, 61 FR 51342, Oct. 1, 1996]

§ 179.300–8 Tank heads.

(a) Class DOT–110A tanks shall have fusion-welded heads formed concave to pressure. Heads for fusion welding shall be an ellipsoid of revolution 2:1 ratio of major to minor axis. They shall be one piece, hot formed in one heat so as to provide a straight flange at least 1½ inches long. The thickness shall not be less than that calculated by the following formula:

$$t = \frac{Pd}{2SE}$$

where symbols are as defined in §179.300–6(a).

(b) Class DOT–106A tanks must have forged-welded heads, formed convex to pressure. Heads for forge welding must be torispherical with an inside radius not greater than the inside diameter of the shell. They must be one piece, hot formed in one heat so as to provide a straight flange at least 4 inches long. They must have snug drive fit into the shell for forge welding. The wall thickness after forming must be sufficient to meet the test requirements of §179.300–16 and to provide for adequate threading of openings.

[29 FR 18995, Dec. 29, 1964. Redesignated at 32 FR 5606, Apr. 5, 1967, and amended by Amdt. 179–10, 36 FR 21355, Nov. 6, 1971]

§ 179.300–9 Welding.

(a) Longitudinal joints must be fusion welded. Head-to-shell joints must be forge welded on class DOT–106A tanks and fusion welded on class DOT–110A tanks. Welding procedures, welders and fabricators must be approved in accordance with AAR Specifications for Tank Cars, appendix W.

(b) Fusion-welded joints must be in compliance with the requirements of AAR Specifications for Tank Cars, appendix W, except that circumferential welds in tanks less than 36 inches inside diameter need not be radiotaped.

(c) Forge-welded joints shall be thoroughly hammered or rolled to insure sound welds. The flanges of the heads shall be forge lapwelded to the shell and then crimped inwardly toward the center line at least one inch on the radius. Welding and crimping must be accomplished in one heat.

[29 FR 18995, Dec. 29, 1964. Redesignated at 32 FR 5606, Apr. 5, 1967, and as amended by Amdt. 179–10, 36 FR 21355, Nov. 6, 1971]

§ 179.300–10 Postweld heat treatment.

After welding is complete, steel tanks and all attachments welded thereto, must be postweld heat treated